

Date: Wednesday, 3/14/2007 3:27:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 204 STEP LUG
 Job Number : 31210
 Estimate Number : 11844
 P.O. Number : N/A Part Number : D23382
 This Issue : 3/14/2007 S.O. No. : N/A Drawing Number : D2338 REV B U/R
 Prsht Rev. : NC Project Number : N/A
 First Issue : 3/14/2007 Type : MACHINED PARTS Drawing Revision : B
 Previous Run : Material : N/A
 Written By : Due Date : 3/23/2007 Qty: 6 Um: Each
 Checked & Approved By :
 Comment : Est. B00.03.24 Separated -1 from -2 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 0.3827 f(s)/Unit Total: 2.2964 f(s)

6061-T6 Bar .50" x 6.0"

* Material: 6061-T6 0.5 x 6.0"

Batch: 1103436

1 blank makes one D2338-1 & one D2338-2

07/03/19

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks 8.75" long

07/03/19

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2338

Tumble & Deburr

SA / 07/03/19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / 07.03.20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/20 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/03/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 204 STEP LUG

Job Number: 31210

Part Number: D23382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/13/22 (C)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



07/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

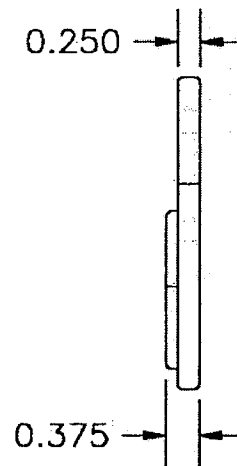


DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>B.S.</i>	APPROVED	<i>B.S.</i>	DRAWING NO. D2338
DATE	95:01:25	TITLE	ENDPLATE	REV. B SHEET 1 OF 1
	B	96.03.29	RE-DESIGN AND ADD D2338-2	SCALE 1:2

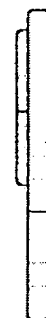
RELEASED
47/04/22

UNDER REVIEW

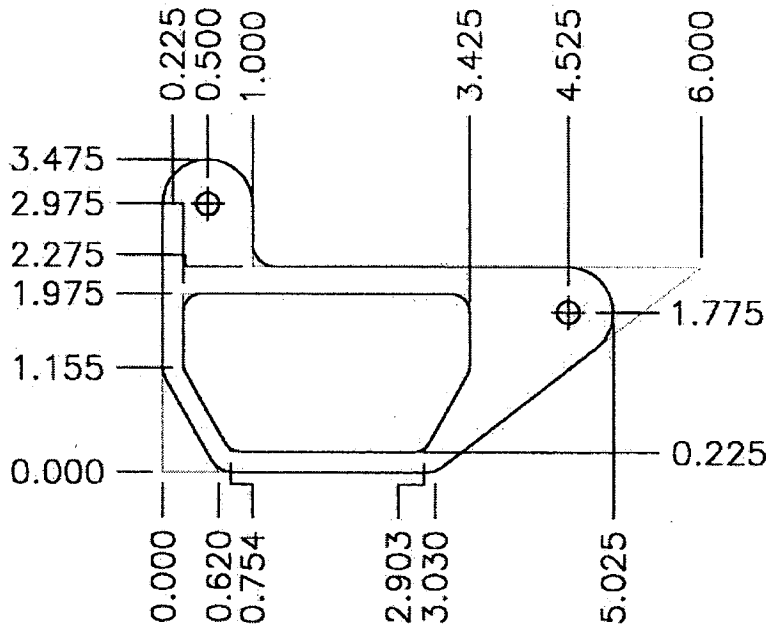
02.11.11



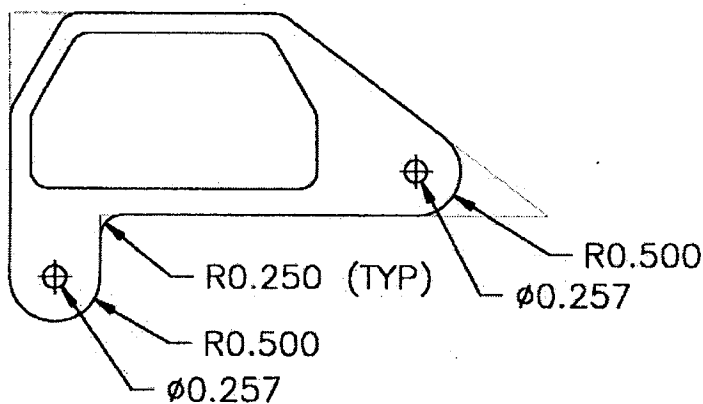
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

DART AEROSPACE LTD		Work Order: 31210
Description: 204 Step Lng		Part Number: 12338-2
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A							
B							
C							
D							
E							
F							
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SA	Audited by: J.F.	Prototype Approval:	N/A
Date: 07-03-20	Date: 07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	